

## Technical information

Art.-Nr. **1.390 / 1** - example inox



### VHM - INOX-Hochleistungsfräser

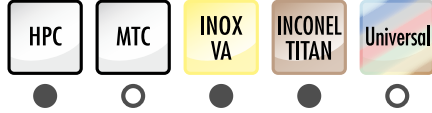
Art.-Nr. **1.390** Flutes **4**



#### Tool data



#### Tool recommendation



#### Capabilities



## Areas of application and special features

Successful in difficult materials like Inox, titanium, Inconel und Nimonic.  
Uneven partition, uneven helix, form flute and polished highend coating.

## Competitive advantages and profitability

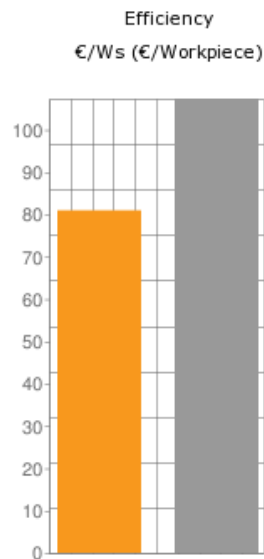
competition to Hoffmann Tisi and WNT Monstermill

## Example application

Art.-Nr.: **1.390.160.10**  
Material: **Rust and acid constant steels <700 N/mm² (<205 HB)**

Competitor: **bekannt**  
Art.-Nr.: **unbekannt**

Inovatools – Roughing			
D1	16,00	mm	Diameter
z	4		Flutes
ae	16,000	mm	Row pitch
ap	16,000	mm	Cutting depth
vc	60,10	m/min	Cutting speed
n	1196	U/min	Rotation speed
fz	0,05886	mm	Feed per tooth
vf	281,54	mm/min	Feed rate
Q	72,07333000	cm³/min	Material removal rate
hm	0,03747	mm	Middle chipping thickness
K/M	80	€/std	Machine hourly cost
K/W	62	€	Tool cost
T	32	min	Tool life
V	1792	cm³	Processing volume
Tb	24,86	min	Process time
€/Ws	81,31	€	Cost workpiece



Calculator			
D1	16,00	mm	Diameter
z	4		Flutes
ae	16	mm	Row pitch
ap	16	mm	Cutting depth
vc	100	m/min	Cutting speed
n	1989	U/min	Rotation speed
fz	0,05	mm	Feed per tooth
vf	397,89	mm/min	Feed rate
Q	101,85916358	cm³/min	Material removal rate
hm	0,03183	mm	Middle chipping thickness
K/M	80	€/std	Machine hourly cost
K/W	62	€	Tool cost
T	13	min	Tool life
V	1792	cm³	Processing volume
Tb	17,59	min	Process time
€/Ws	107,34	€	Cost workpiece

